

Date: Wednesday, 11/21/2007 12:51:41 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	CABIN FLOOR PROTECTOR
Job Number	35947		
Estimate Number	12969		
P.O. Number	N/A	Part Number	D35745
This Issue	11/21/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D3574 REV.A
First Issue	N/A	Project Number	N/A
Previous Run	35100	Drawing Revision	A
Written By		Material	N/A
Checked & Approved By		Due Date	11/28/2007
Comment	Est Rev A New Issue 07.07.23 EC verified by:JLM	Qty:	4 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	F60029	lexan grey
	Comment: Qty.: 32.0000 sf(s)/Unit Total : 128.0000 sf(s) F60029 lexan sheet Batch: 10S330 1B 07-11-21	
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET 1-Cut as per Dwg D3574 Dwg Rev: A Prog Rev: A	(4)
	2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	1B 07-11-21
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	5 07/11/22 (x4)
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1	
	Deburr if necessary.	SAD 07-11-24 (9)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/11/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/21/2007 12:51:41 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABIN FLOOR PROTECTOR

Job Number: 35947

Part Number: D35745

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: _____

07/11/26 (4)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/11/27

Job Completion



07/11/27

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

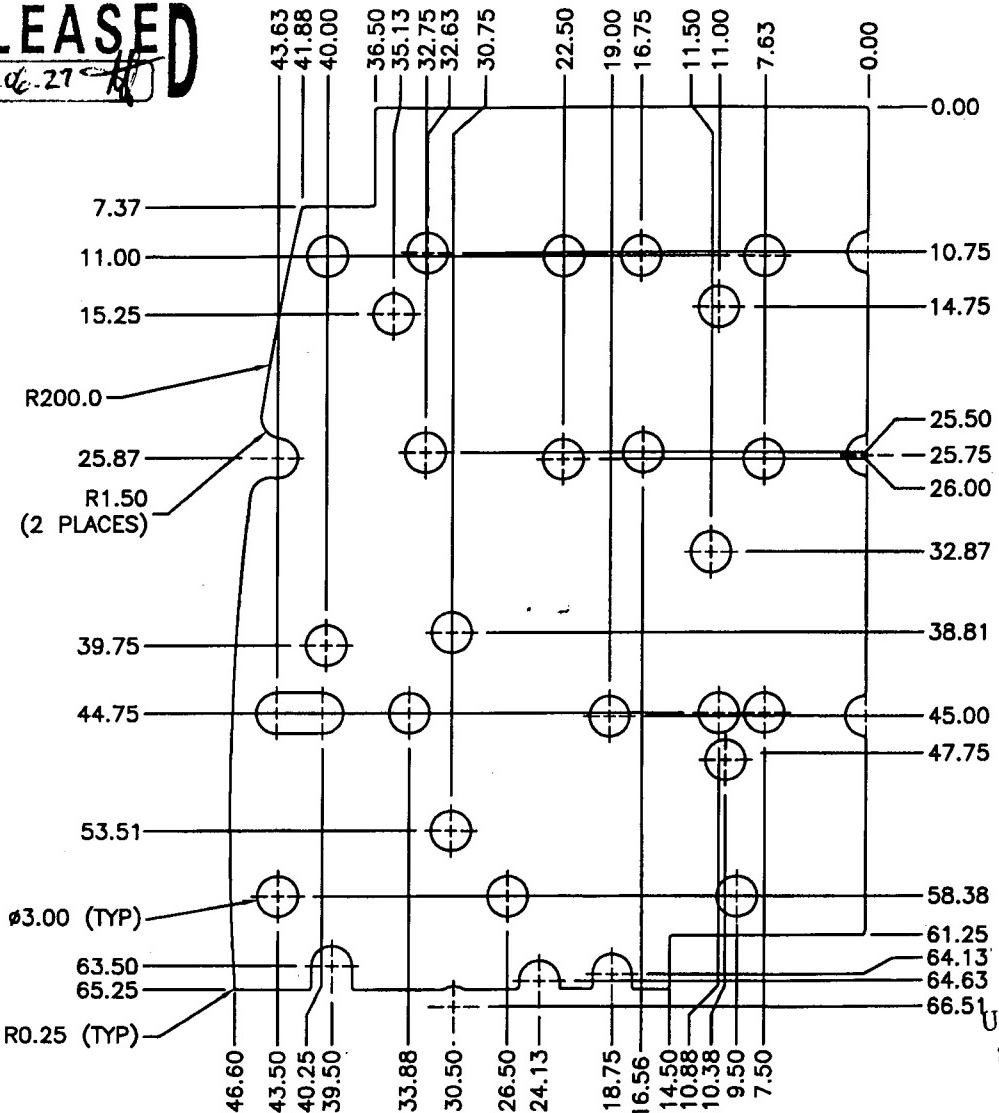
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART

DESIGN <i>CE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>CE</i>	APPROVED <i>CH</i>	DRAWING NO. D3574	REV. A	SHEET 1 OF 5
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14	
A	07.06.08	NEW ISSUE		

RELEASED
07.06.21

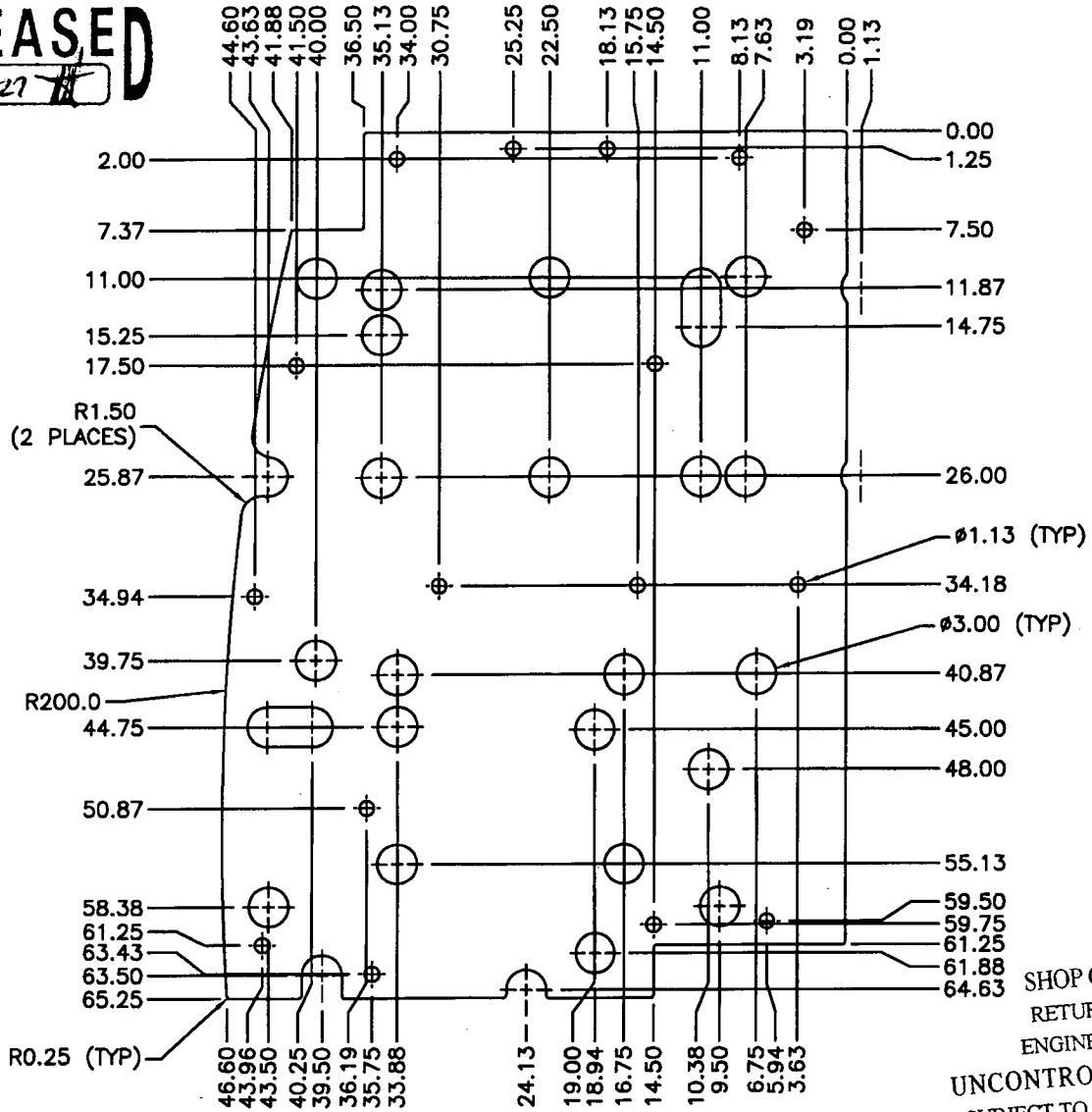
SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
3594

D3574-1 CABIN FLOOR PROTECTOR (SHOWN). D3574-2 (OPPOSITE)**NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-1/-2" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8961

DART

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CHECKED <i>CE</i>	APPROVED <i>H</i>	DRAWING NO. D3574	REV. A SHEET 2 OF 5
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

RELEASED
07.06.08

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WORK ORDER
NO. *35747*

D3574-3 CABIN FLOOR PROTECTOR**NOTES:**

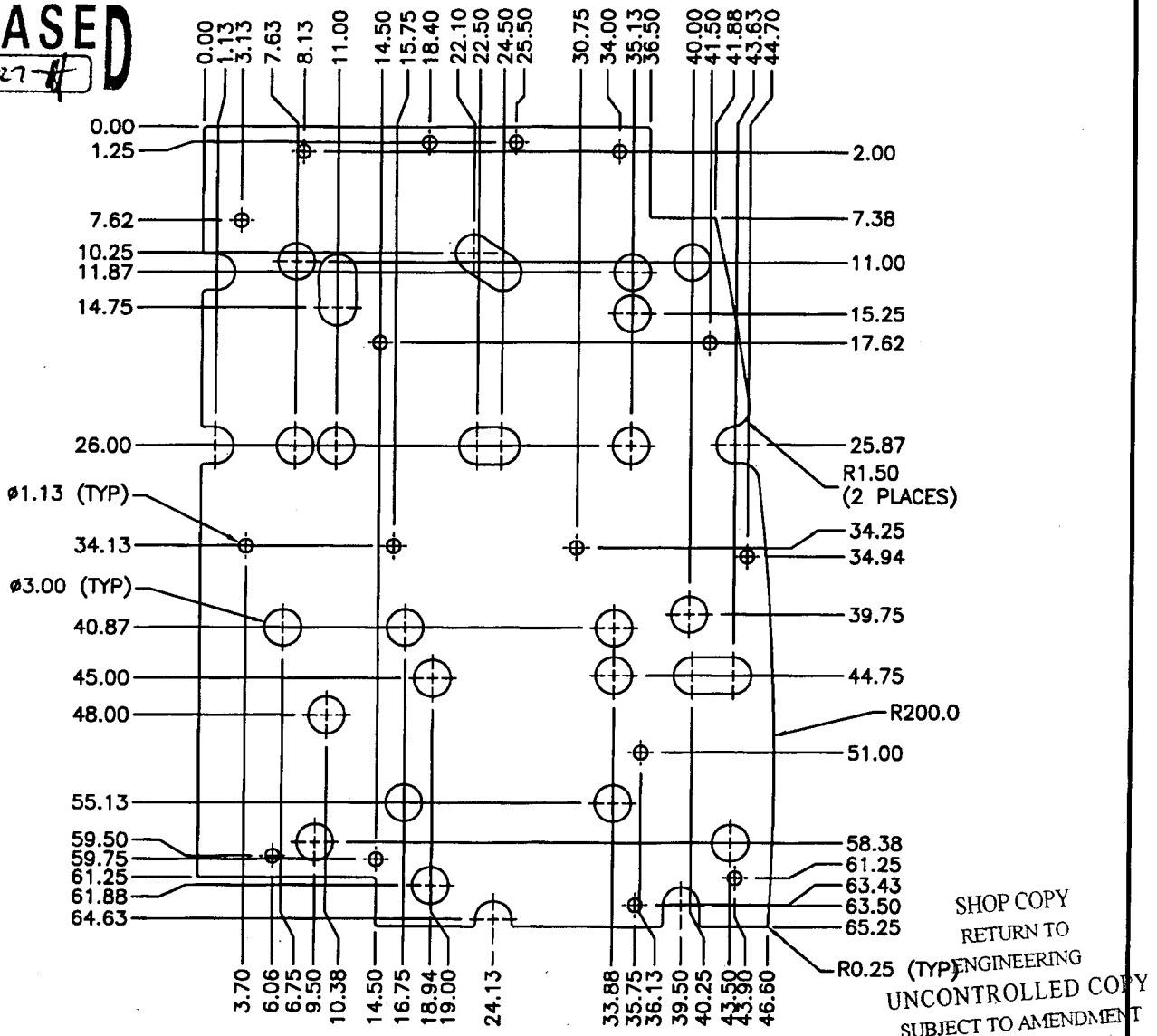
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-3" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8962

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DESIGN <i>CE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>CE</i>	APPROVED <i>dk</i>	DRAWING NO. D3574
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR

REV. A
SHEET 3 OF 5
SCALE
1:14**RELEASED**
67.06.27-4**NOTES:**

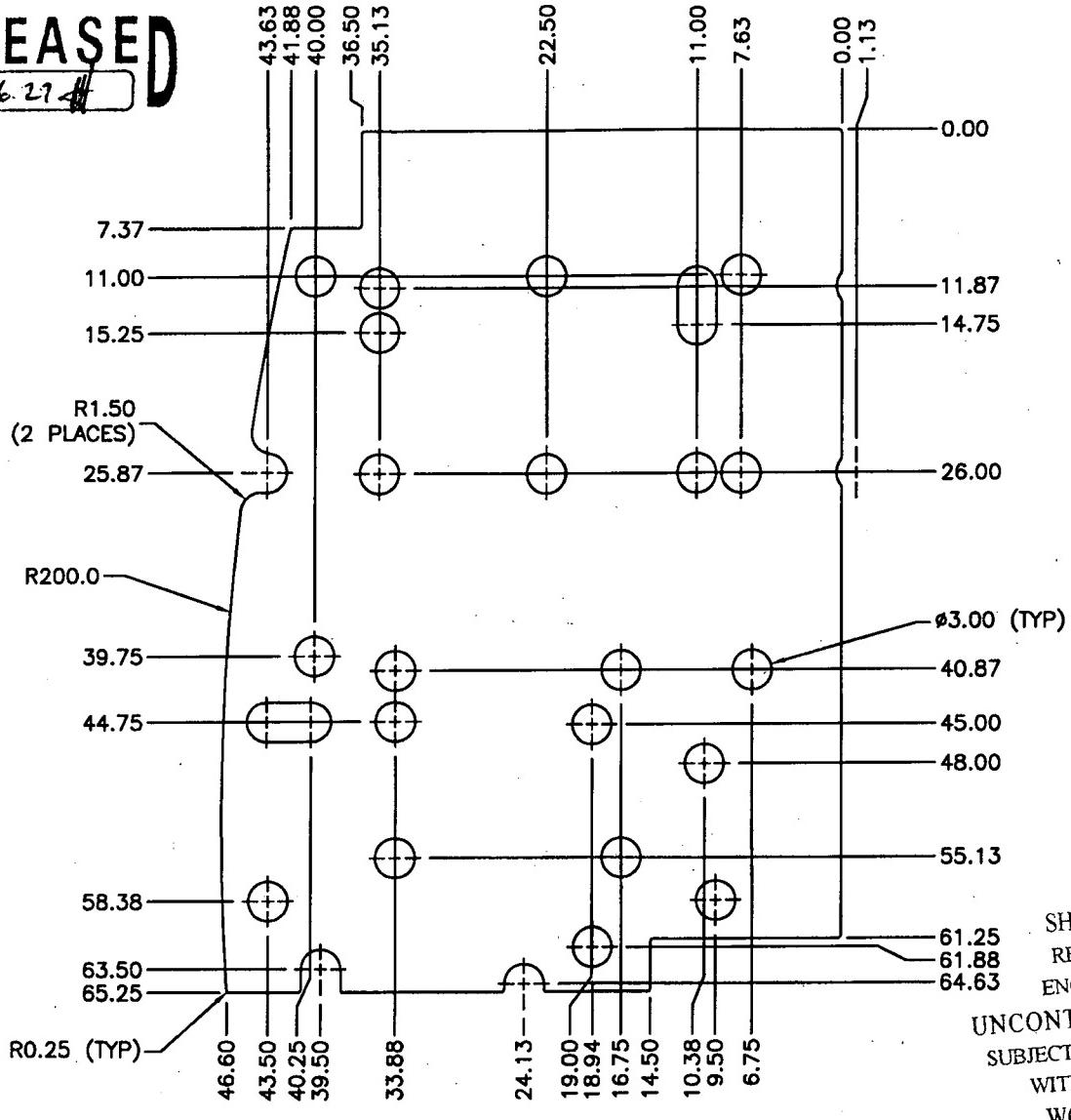
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-4" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8963

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CHECKED <i>CE</i>	APPROVED <i>H</i>	DRAWING NO. D3574	REV. A SHEET 4 OF 5
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

RELEASED
07.06.27**D3574-5 CABIN FLOOR PROTECTOR**

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WITHOUT NOTICE
WORK ORDER
NO. *3574-1*

NOTES:

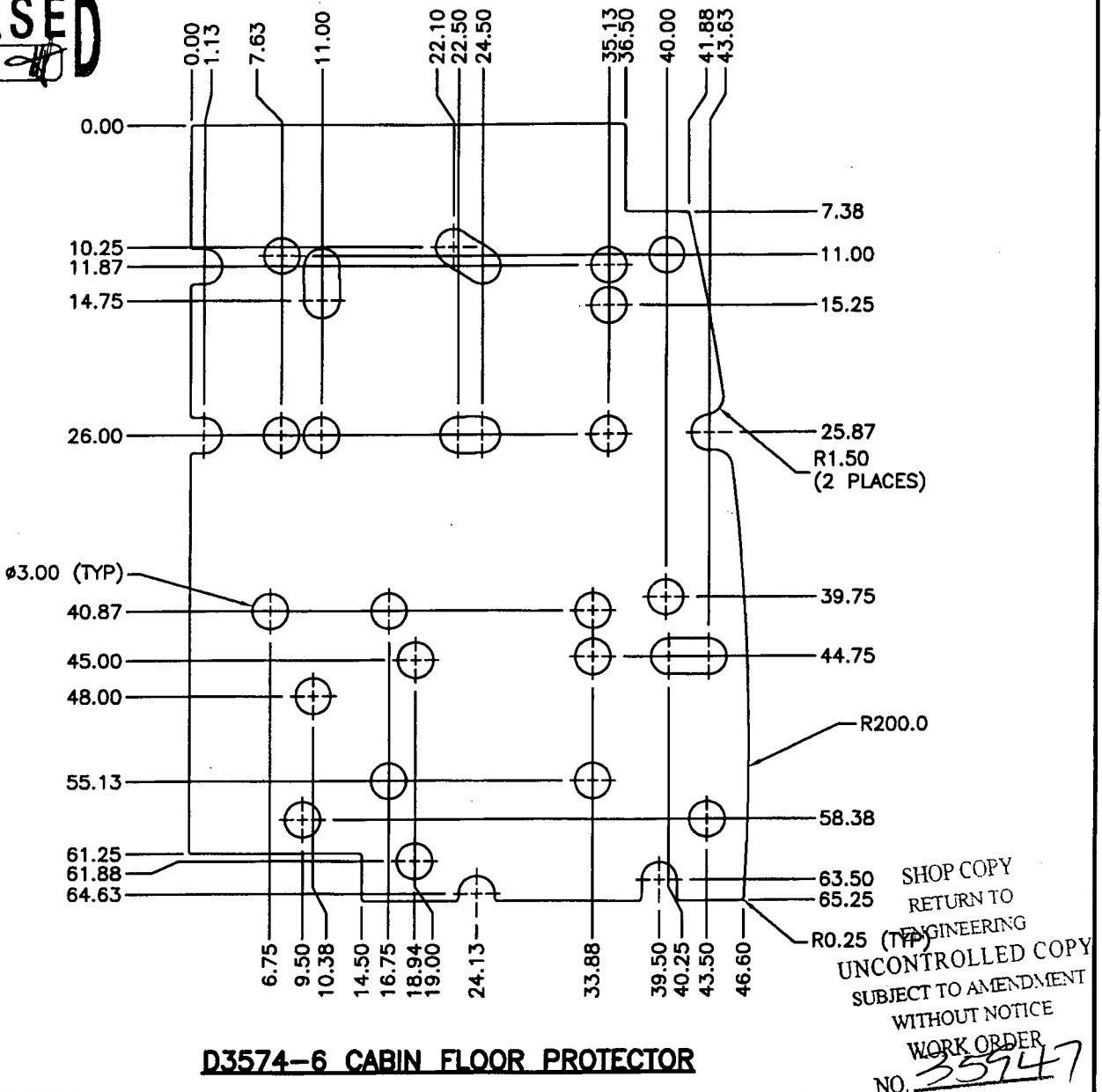
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-5" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8964

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CHECKED <i>CE</i>	APPROVED <i>JK</i>	DRAWING NO. D3574	REV. A SHEET 5 OF 5
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

RELEASED
07.06.08**D3574-6 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-6" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8965

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DART AEROSPACE LTD	Work Order:	35947
Description: CABIN FLOOR PROTECTOR	Part Number:	D3574-S
Inspection Dwg: D3574-S Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
$\phi .300$	$+.006 -.001$	3.003	X			
7.37	$+- .030$	7.37	X			
11.00	$+- .030$	11.00	X			
15.25	$+- .030$	15.25	X			
25.87	$+- .030$	25.87	X			
39.75	$+- .030$	39.75	X			
44.75	$+- .030$	44.75	X			
58.38	$+- .030$	58.38	X			
63.50	$+- .030$	63.50	X			
65.25	$+- .030$	65.25	X			
11.87	$+- .030$	11.87	X			
14.75	$+- .030$	14.75	X			
26.00	$+- .030$	26.00	X			
40.87	$+- .030$	40.87	X			
45.06	$+- .030$	45.00	X			
48.06	$+- .030$	48.00	X			
55.13	$+- .030$	55.13	X			
61.25	$+- .030$	61.25	X			
61.88	$+- .030$	61.88	X			
64.63	$+- .030$	64.63	X			

Measured by:	HB	Audited by:	S	Prototype Approval:	✓/4
Date:	07-11-21	Date:	21.11.23	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

2

DART AEROSPACE LTD	Work Order:	35947
Description: CABIN FLOOR PROTECTOR	Part Number:	3574-5
Inspection Dwg: D3574-5 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
7.63	+/- .030	7.63	X			
11.00	+/- .030	11.00	X			
22.50	+/- .030	22.50	X			
35.13	+/- .030	35.13	X			
36.50	+/- .030	36.50	X			
40.00	+/- .030	40.00	X			
41.88	+/- .030	41.88	X			
43.63	+/- .030	43.63	X			
6.75	+/- .030	6.75				
9.50	+/- .030	9.50				
10.38	+/- .030	10.38				
14.50	+/- .030	14.50				
16.75	+/- .030	16.75				
18.94	+/- .030	18.94				
19.00	+/- .030	19.00				
24.13	+/- .030	24.13				
33.88	+/- .030	33.88				
39.50	+/- .030	39.50				
40.25	+/- .030	40.25				
43.50	+/- .030	43.50				
46.60	+/- .030	46.60				

Measured by:	HB	Audited by:	J	Prototype Approval:	<i>a/</i>
Date:	07-11-21	Date:	07/11/22	Date:	<i>a/a</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	